

11. 3125 .058W

Work Order ID 69893



Page 1

Tuesday, May 24, 2011 10:06:33 AM

Item ID:	D3681-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	5/24/2011	Start Qty:	30.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	11-05-24	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3681	Rev A								

100
 Hardinge CNC LATHE SMALL 0.00
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681
 FOLIO REV: 11/5
 DWG REV: A
 2-DEBURR AS REQUIRED

11/5/31

32

110
 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

11/5/31

32

120
 QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

11.5.31

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69893

Tuesday, May 24, 2011 10:06:33 AM



Page 2

Item ID: D3681-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 5/24/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

32 0 BE 11/06/09

130

0.00



Packaging

Identify as per dwg & Stock Location: LG

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

32 0 BE 11/06/09

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/06/09
NF
11-06-09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:06:42 AM

Page 1

Work Order ID: 69893

Parent Item: D3681-1

Parent Item Name: Spacer



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

100

f

128.5390

0.34

10.73684



ALUM TUBE .3125 x .058w



Signature 5/31/11

Location

Loc Qty

Loc Code

MAT013

128.539

116793

1.667

116939

93.972

117400

32.9

12 PF

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

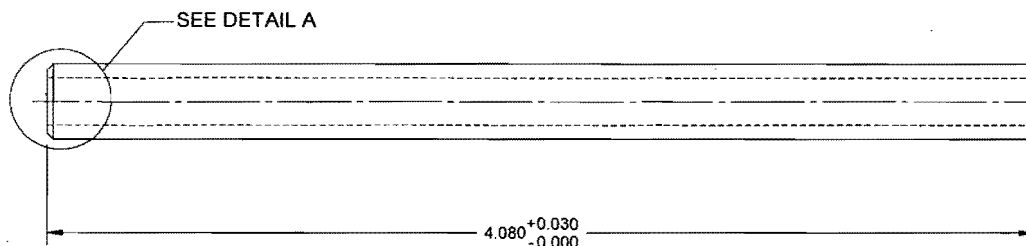
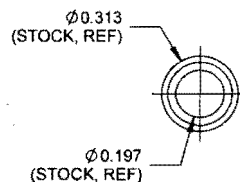
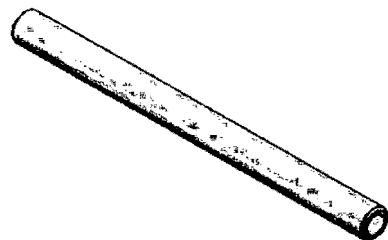
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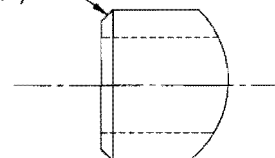
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0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

D3681-1 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69893

11-05-24

RELEASED
07-11-08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC		07.11.08		
REV.		DESCRIPTION			BY		DATE	
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA			REV. A SHEET 1 OF 1 SCALE 2:			
DRAWN								
CHECKED								
MFG. APPR.								
APPROVED								
DE APPR.								
DATE		07.11.08			COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

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